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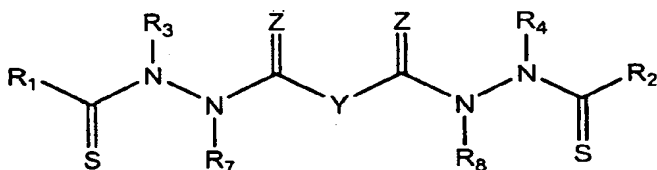
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(54) Title: PURIFICATION OF BIS(THIOHYDRAZIDE AMIDES)



I

(57) Abstract: Disclosed herein are methods of purifying a bis(thio-hydrazide amides) compounds of structural formula (I), wherein R₁, R₂, R₃, R₄, R₇, R₈, Z, and Y are defined herein.



PURIFICATION OF BIS(THIOHYDRAZIDE AMIDES)

RELATED APPLICATION

This application claims the benefit of U.S. Provisional Application No. 60/844,776, filed on September 15, 2006. The entire teachings of the above
5 application(s) are incorporated herein by reference.

BACKGROUND OF THE INVENTION

Cancer is a group of diseases that are characterized by uncontrolled cell division. This uncontrolled division can compromise the function of an organism and ultimately may cause its death.

10 On average, in the United States, men have a 1 in 2 lifetime risk of developing cancer and women, a 1 in 3 risk. The International Agency for Research on Cancer estimated that there were 5.3 million new cases of cancer and 3.5 million cancer deaths worldwide in 2000. In the United States, more than 1.2 million new cases were diagnosed in 2002 and more than 550,000 people died of the disease. In fact, cancer is the second leading cause of death in the
15 United States, exceeded only by heart disease.

Many cancers are immunosensitive. Immunosensitive cancers respond to immunotherapy, i.e., agents that stimulate the immune system. Examples of immunosensitive cancers include, renal cell carcinoma, melanoma, multiple myeloma, myeloma, lymphoma, non-small-cell lung cancer, bladder cancer, prostate cancer, squamous cell carcinoma, basal
20 cell carcinoma, fibrosarcoma, malignant brain tumors, Kaposi's Sarcoma, chronic myelogenous leukemia (CML) and hairy cell leukemia.

Heat shock proteins (HSPs) are found in virtually all prokaryotic and eukaryotic cells where they support folding of nascent polypeptides, prevent protein aggregation, and assist transport of other proteins across membranes. The proteins in the Hsp70 family (referred to
25 collectively as "Hsp70") play a dual role of protecting cells from lethal damage after environmental stress, on the one hand, and targeting cells for immune mediated cytolytic attack on the other hand. Increased expression of Hsp70 in the cytoplasm is known to protect a broad range of cells under stress by preventing the misfolding, aggregation and denaturation of cytoplasmic proteins and inhibiting various apoptotic pathways (Mosser, *et*
30 *al.*, Mol Cell Biol. 2000 October; 20(19): 7146–7159; Yenari, Adv Exp Med Biol, 2002, 513,

281-299; Kiang and Tsokos, *Pharmacol Ther.* 1998; 80(2):182-201). However, membrane-bound Hsp70 provides a target structure for cytolytic attack mediated by natural killer cells.

Cells can experience stress due to temperature; injury (trauma); genetic disease; metabolic defects; apoptosis; infection; toxins; radiation; oxidants; excess/lack of nutrients or metabolic products; and the like. For example, it is known in the art that cells damaged in the following variety of medical conditions can experience a protective effect in response to Hsp70.

Protein misfolding/aggregation conditions resulting in neurodegeneration include Alzheimer's disease (Zhang, *et al.*, *J. Neuroscience*, 2004, 24(23), 5315-5321; Klettner, *Drug News Perspect*, 2004 17(5), 299-306); Huntington's disease (Klettner, *ibid*); Parkinson's disease (Auluck, *et al.*, *Science*, 2002, 295(5556), 865-868); and the like. Other neurodegenerative conditions include spinal/bulbar muscular atrophy (Sobue, *Nihon Shinkei Seishin Yakurigaku Zasshi*, 2001, 21(1), 21-25); and familial amyotrophic lateral sclerosis (Howland, *et al.*, *Proc Nat Acad Sci USA*, 2002, 99(3), 1604-1609; Sobue, *ibid*; Vlemminck, *et al.*, *J Neuropathol Exp Neurol*, 2002, 61(11), 968-974).

Ischemia and associated oxidative damage affects diverse tissues including: neurons and glia (Carmel, *et al.*, *Exp Neurol*, 2004, 185(1) 81-96; Renshaw and Warburton, *Front Biosci*, 2004, 9, 110-116; Yenari, *Adv Exp Med Biol*, 2002, 513, 281-299; Kelly and Yenari, *Curr Res Med Opin*, 2002, 18 Suppl 2, s55-60; Lee, *et al.*, *Exp Neurol*, 2001, 170(1), 129-139; Klettner, *ibid*; Klettner and Herdegen, *Br J Pharmacol*, 2003, 138(5), 1004-1012); cardiac muscle (Marber, M.S., *et al.* (1995) *J. Clin. Invest.* 95:1446-1456; Plumier, J.C., *et al.* (1995) *J. Clin. Invest.* 95:1854-1860; Radford, N.B., *et al.* (1996) *Proc. Natl. Acad. Sci. USA* 93(6): 2339-2342; Voss, *et al.*, *Am J Physiol Heart Circ Physiol* 285: H687-H692, 2003); liver tissue (Doi, *et al.*, *Hepatogastroenterology*. 2001 Mar-Apr;48(38):533-40; Gao, *et al.* *World J Gastroenterol* 2004;10(7):1019-1027); skeletal muscle (Lepore *et al.*, *Cell Stress & Chaperones*, 2001, 6(2), 93-96); kidney tissue (Chen, *et al.*, *Kidney Int.* 1999; 56: 1270-1273; Beck, *et al.*, *Am J Physiol Renal Physiol* 279: F203-F215, 2000.); pulmonary tissue (Hiratsuka, *et al.*, *J Heart Lung Transplant.* 1998 Dec;17(12):1238-46); pancreatic tissue (Bellmann, *et al.*, *J Clin Invest.* 1995 June; 95(6): 2840-2845), and the like.

Seizure conditions that damage neurons include, e.g., epileptic seizure (Yenari, *ibid*; Blondeau, *et al.* *Neuroscience* 2002, 109(2), 231-241); or chemically induced seizure (Tsuchiya, *et al.*, *Neurosurgery*, 2003, 53(5), 1179-1187).

Thermal stresses include hyperthermia conditions such as fever, heat stroke, and the like (Barclay and Robertson, *J Neurobiol*, 2003 56(4), 360-271; Sato, *et al.*, *Brain Res*, 1996,

740(1-2), 117-123); and hypothermia (Kandor and Goldberg, Proc Natl Acad Sci U S A. 1997 May 13; 94(10): 4978-4981).

Aging includes conditions such as atherosclerosis which affects smooth muscle cells (Minowada, G. and Welch, W.J. (1995) J. Clin. Invest. 95:3-12; Johnson, A.J., *et al.* (1995) 5 Arterio. Thromb. Vasc. Biol. 15(1):27-36).

Other conditions include radiation damage, e.g., from ultraviolet light to tissues such as murine fibroblasts (Simon, M.M., *et al.* (1995) J. Clin. Res. 95(3): 926-933), and light damage to retinal cells (Yu, et, al, Molecular Vision 2001; 7:48-56).

Trauma includes, for example, mechanical injury, e.g., pressure damage to retinal 10 ganglions in glaucoma (Ishii, *et al.*, Invest Ophthalmol Vis Sci, 2003, 44(5), 1982-1992).

Toxic conditions include doses of chemicals or biochemicals, for example, methamphetamine (Malberg & Seiden, Poster "MDMA Administration Induces Expression of HSP70 in the Rat Brain" Society for Neuroscience Annual Meeting, New Orleans, LA, October 25-30, 1997); antiretroviral HIV therapeutics (Keswani, *et al.*, Annals Neurology, 15 2002, 53(1), 57-64); heavy metals, amino acid analogs, chemical oxidants, ethanol, glutamate, and other toxins (Ashburner, M. and Bonner, J.J. (1979) Cell: 17:241-254; Lindquist, S. (1986) Ann. Rev. Biochem. 55:1151-1191; Craig, E.A. (1985) Crit. Rev. Biochem. 18(3):239-280; Morimoto, *et al.*, In: The Biology of Heat Shock Proteins and Molecular Chaperone, (1994) pp. 417-455. Cold Spring Harbor Laboratory Press. Cold Spring Harbor, 20 N.Y.); and the like.

Cystic fibrosis is a genetic disorder which results from a mutation in a single glycoprotein called the cystic fibrosis transmembrane conductance regulator (CFTR). As a result of the mutation, post-translational processing of CFTR cannot proceed correctly and the glycoprotein fails to be delivered to the cell membrane. Induction of Hsp70 has been shown 25 to overcome this defective processing and results in functional CFTR protein on the cell surface (Choo-Kang and Zeitlin, *Am. J. Physiol. Lung Cell Mol. Physiol.* (2001), 281:L58-L68).

Therefore, there is a need for new methods of increasing expression of Hsp70 in order to treat disorders responsive to Hsp70.

30 Extracellular Hsp70 and membrane bound Hsp70 have been shown to play key roles in activation of the innate immune system. Monocytes have been shown to secrete proinflammatory cytokines in response to soluble Hsp70 protein and membrane bound Hsp70 has been shown to provide a target structure for cytolytic attack by natural killer cell.

Natural killer (NK) cells, a type of white blood cell, are known to be an important component of the body's immune system. Because the defining function of NK cells is spontaneous cytotoxicity without prior immunization, NK cells can be the first line of defense in the immune system, and are believed to play a role in attacking cancer cells and infectious diseases. Many conditions, such as immunodeficiency diseases, aging, toxin exposure, endometriosis, and the like can leave subjects with lowered NK cell activity or dysfunctional NK cells.

For example, subjects can have decreased or deficient NK cell activity, in conditions such as chronic fatigue syndrome (chronic fatigue immune dysfunction syndrome) or Epstein-Barr virus, post viral fatigue syndrome, post-transplantation syndrome or host-graft disease, exposure to drugs such as anticancer agents or nitric oxide synthase inhibitors, natural aging, and various immunodeficiency conditions such as severe combined immunodeficiency, variable immunodeficiency syndrome, and the like. (Caligiuri M, Murray C, Buchwald D, Levine H, Cheney P, Peterson D, Komaroff AL, Ritz J. Phenotypic and functional deficiency of natural killer cells in patients with chronic fatigue syndrome. *Journal of Immunology* 1987; 139: 3306-13; Morrison LJA, Behan WHM, Behan PO. Changes in natural killer cell phenotype in patients with post-viral fatigue syndrome. *Clinical and Experimental Immunology* 1991; 83: 441-6; Klingemann, HG Relevance and Potential of Natural Killer Cells in Stem Cell Transplantation *Biology of Blood and Marrow Transplantation* 2000;6:90-99; Ruggeri L, Capanni M, Mancusi A, Aversa F, Martelli MF, Velardi A. Natural killer cells as a therapeutic tool in mismatched transplantation. *Best Pract Res Clin Haematol.* 2004 Sep;17(3):427-38; Cifone MG, Ullisse S, Santoni A. Natural killer cells and nitric oxide. *Int Immunopharmacol.* 2001 Aug;1(8):1513-24; Plackett TP, Boehmer ED, Faunce DE, Kovacs EJ. Aging and innate immune cells. *J Leukoc Biol.* 2004 Aug;76(2):291-9. Epub 2004 Mar 23; Alpdogan O, van den Brink MR. IL-7 and IL-15: therapeutic cytokines for immunodeficiency. *Trends Immunol.* 2005 Jan;26(1):56-64; Heusel JW, Ballas ZK. Natural killer cells: emerging concepts in immunity to infection and implications for assessment of immunodeficiency. *Curr Opin Pediatr.* 2003 Dec;15(6):586-93; Hacein-Bey-Abina S, Fischer A, Cavazzana-Calvo M. Gene therapy of X-linked severe combined immunodeficiency. *Int J Hematol.* 2002 Nov;76(4):295-8; Baumert E, Schlesier M, Wolff-Vorbeck G, Peter HH. Alterations in lymphocyte subsets in variable immunodeficiency syndrome *Immun Infekt.* 1992 Jul;20(3):73-5.)

NK cells are known to have activity against a wide range of infectious pathogens such as bacteria, viruses, fungi, protozoan parasites, combined infections, e.g., combined

bacterial/viral infections, and the like. NK cells are believed to be particularly important in combating intracellular infections where the pathogens replicate in the subjects cells, e.g., a substantial fraction of viruses and many other pathogens that can form intracellular infections.

For example, a wide range of fungal infections are reported to be targeted by NK cells
5 such as *Cryptococcus neoformans*, dermatophytes, e.g., *Trichophyton rubrum*, *Candida albicans*, *Coccidioides immitis*, *Paracoccidioides brasiliensis*, or the like (Hidore MR, Mislan TW, Murphy JW. Responses of murine natural killer cells to binding of the fungal target *Cryptococcus neoformans* Infect Immun. 1991 Apr;59(4):1489-99; Akiba H, Motoki Y, Satoh M, Iwatsuki K, Kaneko F; Recalcitrant trichophytic granuloma associated with NK-cell
10 deficiency in a SLE patient treated with corticosteroid. Eur J Dermatol. 2001 Jan-Feb;11(1):58-62; Mathews HL, Witek-Janusek L. Antifungal activity of interleukin-2-activated natural killer (NK1.1+) lymphocytes against *Candida albicans*. J Med Microbiol. 1998 Nov;47(11):1007-14; Ampel NM, Bejarano GC, Galgiani JN. Killing of *Coccidioides immitis* by human peripheral blood mononuclear cells. Infect Immun. 1992
15 Oct;60(10):4200-4; Jimenez BE, Murphy JW. In vitro effects of natural killer cells against *Paracoccidioides brasiliensis* yeast phase. Infect Immun. 1984 Nov;46(2):552-8.)

Also targeted by NK cells are bacteria, especially intracellular bacteria, e.g., *Mycobacterium tuberculosis*, *Mycobacterium avium*, *Listeria monocytogenes*, many different viruses, such as human immunodeficiency virus, herpesviruses, hepatitis, and the like, and
20 viral/bacterial co-infection (Esin S, Batoni G, Kallenius G, Gaines H, Campa M, Svenson SB, Andersson R, Wigzell H. Proliferation of distinct human T cell subsets in response to live, killed or soluble extracts of *Mycobacterium tuberculosis* and *Myco. avium*. Clin Exp Immunol. 1996 Jun;104(3):419-25; Kaufmann SH. Immunity to intracellular bacteria. Annu Rev Immunol. 1993;11:129-63; See DM, Khemka P, Sahl L, Bui T, Tilles JG. The role of
25 natural killer cells in viral infections. Scand J Immunol. 1997 Sep;46(3):217-24; Brenner BG, Dascal A, Margolese RG, Wainberg MA. Natural killer cell function in patients with acquired immunodeficiency syndrome and related diseases. J Leukoc Biol. 1989 Jul;46(1):75-83; Kottlilil S. Natural killer cells in HIV-1 infection: role of NK cell-mediated non-cytolytic mechanisms in pathogenesis of HIV-1 infection. Indian J Exp Biol. 2003
30 Nov;41(11):1219-25; Herman RB, Koziel MJ. Natural killer cells and hepatitis C: is losing inhibition the key to clearance? Clin Gastroenterol Hepatol. 2004 Dec;2(12):1061-3; Beadling C, Slifka MK. How do viral infections predispose patients to bacterial infections? Curr Opin Infect Dis. 2004 Jun;17(3):185-91)

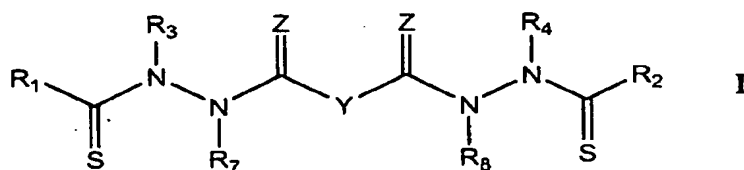
In addition, NK cells combat protozoal infections including toxoplasmosis, trypanosomiasis, leishmaniasis and malaria, especially intracellular infections (Korbel DS, Finney OC, Riley EM. Natural killer cells and innate immunity to protozoan pathogens. *Int J Parasitol.* 2004 Dec;34(13-14):1517-28; Ahmed JS, Mehlhorn H. Review: the cellular basis of the immunity to and immunopathogenesis of tropical theileriosis. *Parasitol Res.* 1999 Jul;85(7):539-49; Osman M, Lausten SB, El-Sefi T, Boghdadi I, Rashed MY, Jensen SL. Biliary parasites. *Dig Surg.* 1998;15(4):287-96; Gazzinelli RT, Denkers EY, Sher A. Host resistance to *Toxoplasma gondii*: model for studying the selective induction of cell-mediated immunity by intracellular parasites. *Infect Agents Dis.* 1993 Jun;2(3):139-49; Askonas BA, Bancroft GJ. Interaction of African trypanosomes with the immune system. *Philos Trans R Soc Lond B Biol Sci.* 1984 Nov 13;307(1131):41-9; Allison AC, Eugui EM. The role of cell-mediated immune responses in resistance to malaria, with special reference to oxidant stress. *Annu Rev Immunol.* 1983;1:361-92.)

NK cells have been shown to play a role in attacking cancer cells that present membrane bound Hsp70. It is believed that membrane bound Hsp70 binds to CD94 receptors on the surface of NK cells and cause them to produce and secrete high amounts of the enzyme, granzyme B which is thought to enter the tumor cell via interaction with membrane bound Hsp70 and induce apoptosis (see Radons and Multhoff, *Exerc. Immunol. Rev.* (2005), 11:17-33). Therefore, there is an urgent need for effective treatments for increasing NK cell activity for the treatment of cancer and other disorders that respond to NK induction.

SUMMARY OF THE INVENTION

It has been reported in U.S. Patent No. 6,800,660, U.S. Patent No. 6,762,204, U.S. Patent No. 7,037,940, U.S. Patent No. 7,001,923, and U.S. Patent No. 6,924,312 that certain bis(thio-hydrazide amide) compounds significantly enhance the anti-cancer activity of taxol and taxol analogs. The entire teachings of these patents are incorporated by reference herein in their entirety. Disclosed herein are methods of purifying these bis(thio-hydrazide amide) compounds.

One embodiment of the present invention is a method of purifying a compound represented by Structural Formula I:



or a tautomer, pharmaceutically acceptable salt, solvate, clathrate, or prodrug thereof, wherein

Y is a covalent bond or an optionally substituted straight chained hydrocarbyl group, or, Y, taken together with both $>C=Z$ groups to which it is bonded, is an optionally substituted aromatic group;

R_1 - R_4 are independently -H, an optionally substituted aliphatic group, an optionally substituted aryl group, or R_1 and R_3 taken together with the carbon and nitrogen atoms to which they are bonded, and/or R_2 and R_4 taken together with the carbon and nitrogen atoms to which they are bonded, form a non-aromatic ring optionally fused to an aromatic ring;

R_7 - R_8 are independently -H, an optionally substituted aliphatic group, or an optionally substituted aryl group; and

Z is O or S;

comprising dissolving the compound in a solvent consisting of THF-acetone or THF- CH_3CN , and precipitating the compound with water.

DETAILED DESCRIPTION OF THE INVENTION

The present invention relates to methods of purifying bis(thio-hydrazide amides) represented by Structural Formula I and pharmaceutically acceptable salts and solvates of the compounds represented by Structural Formula I.

In one embodiment, the compound is dissolved in a solvent selected from the group consisting of THF-acetone, THF- CH_3CN , THF, acetone, CH_3CN , THF-EtOH, or acetone-EtOH, and precipitated with water.

In one embodiment, the compound is dissolved in a solvent consisting of THF-acetone or THF- CH_3CN , and precipitated with water.

Another embodiment, further comprises dissolving the precipitate in a second solvent selected from the group consisting of THF-acetone, THF- CH_3CN , THF, acetone, CH_3CN , THF-EtOH, or acetone-EtOH, and precipitating the compound with water.

Another embodiment, further comprises dissolving the precipitate in a second solvent consisting of THF-acetone or THF- CH_3CN , and precipitating the compound with water.

Another embodiment, further comprises washing the precipitate with THF-water.

In another embodiment, the THF-water is in a ratio of 1:3 (v/v).

In another embodiment, the compound, solvent, and water are stirred for 3 to 4 hours.

In another embodiment, the compound, second solvent, and water are stirred for 3 to 4 hours.

In another embodiment, the temperature is 0-4 °C.

In one embodiment, the solvent is THF-acetone.

In another embodiment, the solvent is THF-CH₃CN.

In one embodiment, the second solvent is THF-acetone.

5 In one embodiment, the second solvent is THF-CH₃CN.

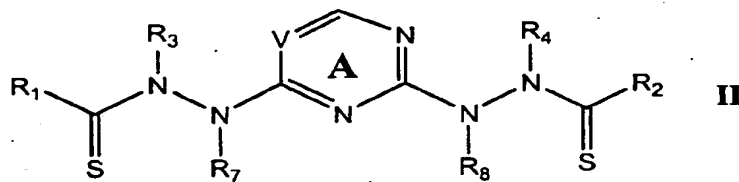
In one embodiment, the solvent is THF-acetone and the second solvent is THF-CH₃CN.

In one embodiment, the solvent is THF-CH₃CN and the second solvent is THF-acetone.

10 In one embodiment, the purified compound is at least 96% pure. In one aspect, the compound is at least 97% pure. In one aspect, the compound is at least 98% pure. In one aspect, the compound is at least 99% pure.

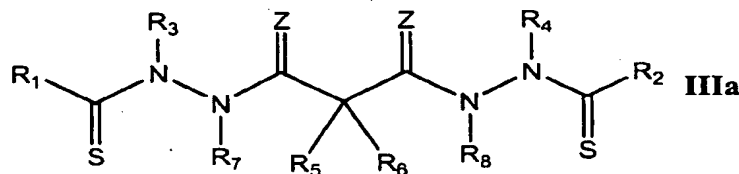
In one embodiment, Y in Structural Formula I is a covalent bond, -C(R₅R₆)-, -(CH₂CH₂)-, trans-(CH=CH)-, cis-(CH=CH)- or -(C≡C)- group, preferably -C(R₅R₆)-. R₁-R₄ are as described above for Structural Formula I. R₅ and R₆ are each independently -H, an aliphatic or substituted aliphatic group, or R₅ is -H and R₆ is an optionally substituted aryl group, or, R₅ and R₆, taken together, are an optionally substituted C2-C6 alkylene group.

In specific embodiments, Y taken together with both >C=Z groups to which it is bonded, is an optionally substituted aromatic group. In this instance, certain bis(thio-hydrazide amides) are represented by Structural Formula II:



or a tautomer, pharmaceutically acceptable salt, solvate, clathrate, or prodrug thereof, wherein Ring A is substituted or unsubstituted and V is -CH- or -N-. The other variables in Structural Formula II are as described herein for Structural Formula I or IIIa.

25 In particular embodiments, the bis(thio-hydrazide amides) are represented by Structural Formula IIIa:



or a tautomer, pharmaceutically acceptable salt, solvate, clathrate, or prodrug thereof, wherein

R₁-R₈ are as described above for Structural Formula I.

5 In Structural Formulas I-IIIa, R₁ and R₂ are the same or different and/or R₃ and R₄ are the same or different; preferably, R₁ and R₂ are the same and R₃ and R₄ are the same. In Structural Formulas I and IIIa, Z is preferably O. Typically in Structural Formulas I and IIIa, Z is O; R₁ and R₂ are the same; and R₃ and R₄ are the same. More preferably, Z is O; R₁ and R₂ are the same; R₃ and R₄ are the same, and R₇ and R₈ are the same.

10 In other embodiments, the bis(thio-hydrazide amides) are represented by Structural Formula IIIa: R₁ and R₂ are each an optionally substituted aryl group, preferably an optionally substituted phenyl group; R₃ and R₄ are each an optionally substituted aliphatic group, preferably an alkyl group optionally substituted with -OH, halogen, phenyl, benzyl, pyridyl, or C1-C8 alkoxy and R₆ is -H or methyl, more preferably, methyl or ethyl group optionally substituted with -OH, halogen, phenyl, benzyl, pyridyl, or C1-C8 alkoxy and R₆ is
15 -H or methyl optionally substituted with -OH, halogen or C1-C4 alkoxy; and R₅ and R₆ are as described above, but R₅ is preferably -H and R₆ is preferably -H, an aliphatic or substituted aliphatic group.

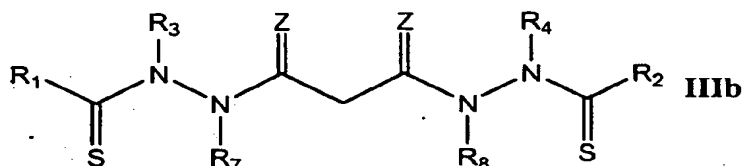
Alternatively, R₁ and R₂ are each an optionally substituted aryl group; R₃ and R₄ are each an optionally substituted aliphatic group; R₅ is -H; and R₆ is -H, an aliphatic or
20 substituted aliphatic group. Preferably, R₁ and R₂ are each an optionally substituted aryl group; R₃ and R₄ are each an alkyl group optionally substituted with -OH, halogen, phenyl, benzyl, pyridyl, or C1-C8 alkoxy and R₆ is -H or methyl; and R₅ is -H and R₆ is -H or methyl. Even more preferably, R₁ and R₂ are each an optionally substituted phenyl group, preferably optionally substituted with -OH, halogen, C1-4 alkyl or C1-C4 alkoxy; R₃ and R₄ are each
25 methyl or ethyl optionally substituted with -OH, halogen or C1-C4 alkoxy; and R₅ is -H and R₆ is -H or methyl. Suitable substituents for an aryl group represented by R₁ and R₂ and an aliphatic group represented by R₃, R₄ and R₆ are as described below for aryl and aliphatic groups.

In another embodiment, the bis(thio-hydrazide amides) are represented by Structural
30 Formula IIIa: R₁ and R₂ are each an optionally substituted aliphatic group, preferably a C3-C8 cycloalkyl group optionally substituted with at least one alkyl group, more preferably cyclopropyl or 1-methylcyclopropyl; R₃ and R₄ are as described above for Structural Formula I, preferably both an optionally substituted alkyl group; and R₅ and R₆ are as described above,

but R₅ is preferably -H and R₆ is preferably -H, an aliphatic or substituted aliphatic group, more preferably -H or methyl.

Alternatively, the bis(thio-hydrazide amides) are represented by Structural Formula **IIIa**: R₁ and R₂ are each an optionally substituted aliphatic group; R₃ and R₄ are as described above for Structural Formula I, preferably both an optionally substituted alkyl group; and R₅ is -H and R₆ is -H or an optionally substituted aliphatic group. Preferably, R₁ and R₂ are both a C3-C8 cycloalkyl group optionally substituted with at least one alkyl group; R₃ and R₄ are both as described above for Structural Formula I, preferably an alkyl group; and R₅ is -H and R₆ is -H or an aliphatic or substituted aliphatic group. More preferably, R₁ and R₂ are both a C3-C8 cycloalkyl group optionally substituted with at least one alkyl group; R₃ and R₄ are both an alkyl group optionally substituted with -OH, halogen, phenyl, benzyl, pyridyl, or C1-C8 alkoxy and R₆ is -H or methyl; and R₅ is -H and R₆ is -H or methyl. Even more preferably, R₁ and R₂ are both cyclopropyl or 1-methylcyclopropyl; R₃ and R₄ are both an alkyl group, preferably methyl or ethyl optionally substituted with -OH, halogen or C1-C4 alkoxy; and R₅ is -H and R₆ is -H or methyl.

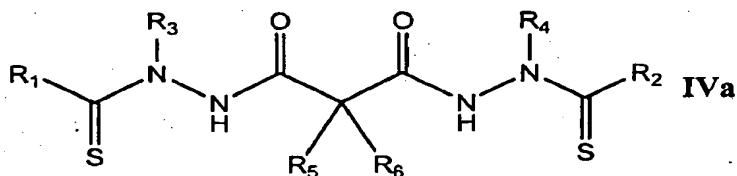
In particular embodiments, the bis(thio-hydrazide amides) are represented by Structural Formula **IIIb**:



or a tautomer, pharmaceutically acceptable salt, solvate, clathrate, or prodrug thereof, wherein

R₁, R₂, R₃, R₄, R₇, R₈, and Z are as defined above for Structural Formula **IIIa**.

In specific embodiments, the bis(thio-hydrazide amides) are represented by Structural Formula **IVa**:



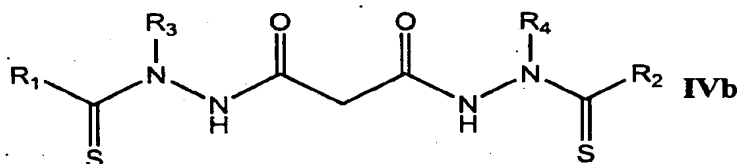
or a tautomer, pharmaceutically acceptable salt, solvate, clathrate, or prodrug thereof, wherein: R₁ and R₂ are both phenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both phenyl, R₃ and R₄ are both ethyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 4-cyanophenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both

- 4-methoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both phenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both phenyl, R₃ and R₄ are both ethyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both 4-cyanophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2,5-dimethoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2,5-dimethoxyphenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both 3-cyanophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 3-fluorophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 4-chlorophenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both 2-dimethoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 3-methoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2,3-dimethoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2,3-dimethoxyphenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both 2,5-difluorophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2,5-difluorophenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both 2,5-dichlorophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2,5-dimethylphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2,5-dimethoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both phenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2,5-dimethoxyphenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both cyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both cyclopropyl, R₃ and R₄ are both ethyl, and R₅ and R₆ are both -H; R₁ and R₂ are both cyclopropyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H; R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, R₅ is methyl and R₆ is -H; R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, R₅ is ethyl, and R₆ is -H; R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, R₅ is *n*-propyl, and R₆ is -H; R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both methyl; R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both ethyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 1-methylcyclopropyl, R₃ is methyl, R₄ is ethyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2-methylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 2-phenylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both 1-phenylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both cyclobutyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both

cyclopentyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both cyclohexyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both cyclohexyl, R₃ and R₄ are both phenyl, and R₅ and R₆ are both -H; R₁ and R₂ are both methyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are both methyl, R₃ and R₄ are both *t*-butyl, and R₅ and R₆ are both -H; R₁ and R₂ are both methyl, R₃ and R₄ are both phenyl, and R₅ and R₆ are both -H; R₁ and R₂ are both *t*-butyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; R₁ and R₂ are ethyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H; or R₁ and R₂ are both *n*-propyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H.

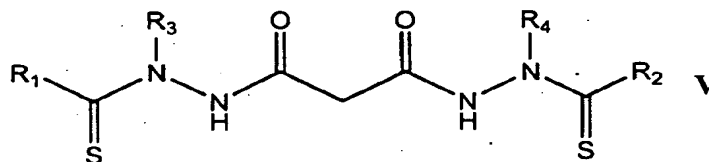
In particular embodiments, the bis(thio-hydrazide amides) are represented by

10 Structural Formula IVb:



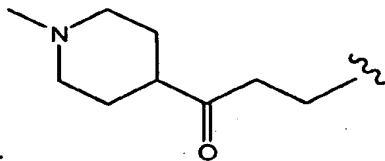
or a tautomer, pharmaceutically acceptable salt, solvate, clathrate, or prodrug thereof, wherein R₁, R₂, R₃, and R₄ are as defined above for Structural Formula IVa.

15 In specific embodiments, the bis(thio-hydrazide amides) are represented by Structural Formula V:



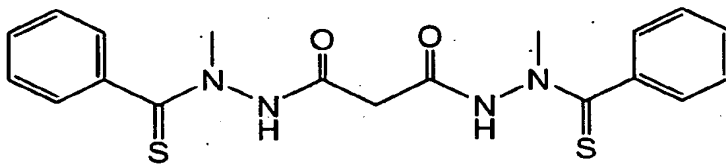
or a tautomer, pharmaceutically acceptable salt, solvate, clathrate, or prodrug thereof, wherein: R₁ and R₂ are both phenyl, and R₃ and R₄ are both *o*-CH₃-phenyl; R₁ and R₂ are both *o*-CH₃C(O)O-phenyl, and R₃ and R₄ are phenyl; R₁ and R₂ are both phenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both phenyl, and R₃ and R₄ are both ethyl; R₁ and R₂ are both phenyl, and R₃ and R₄ are both *n*-propyl; R₁ and R₂ are both *p*-cyanophenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both *p*-nitro phenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2,5-dimethoxyphenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both phenyl, and R₃ and R₄ are both *n*-butyl; R₁ and R₂ are both *p*-chlorophenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 3-nitrophenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 3-cyanophenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 3-fluorophenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2-furanyl, and R₃ and R₄ are both phenyl; R₁ and R₂ are both 2-methoxyphenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both

- 3-methoxyphenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2,3-dimethoxyphenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2-methoxy-5-chlorophenyl, and R₃ and R₄ are both ethyl; R₁ and R₂ are both 2,5-difluorophenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2,5-dichlorophenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2,5-dimethylphenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2-methoxy-5-chlorophenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 3,6-dimethoxyphenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both phenyl, and R₃ and R₄ are both 2-ethylphenyl; R₁ and R₂ are both 2-methyl-5-pyridyl, and R₃ and R₄ are both methyl; or R₁ is phenyl; R₂ is 2,5-dimethoxyphenyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both methyl, and R₃ and R₄ are both *p*-CF₃-phenyl; R₁ and R₂ are both methyl, and R₃ and R₄ are both *o*-CH₃-phenyl; R₁ and R₂ are both -(CH₂)₃COOH; and R₃ and R₄ are both phenyl; R₁ and R₂ are both represented by the following structural

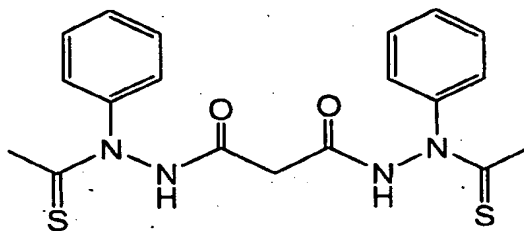


- formula: , and R₃ and R₄ are both phenyl; R₁ and R₂ are both *n*-butyl, and R₃ and R₄ are both phenyl; R₁ and R₂ are both *n*-pentyl, R₃ and R₄ are both phenyl; R₁ and R₂ are both methyl, and R₃ and R₄ are both 2-pyridyl; R₁ and R₂ are both cyclohexyl, and R₃ and R₄ are both phenyl; R₁ and R₂ are both methyl, and R₃ and R₄ are both 2-ethylphenyl; R₁ and R₂ are both methyl, and R₃ and R₄ are both 2,6-dichlorophenyl; R₁-R₄ are all methyl; R₁ and R₂ are both methyl, and R₃ and R₄ are both *t*-butyl; R₁ and R₂ are both ethyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both *t*-butyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both cyclopropyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both cyclopropyl, and R₃ and R₄ are both ethyl; R₁ and R₂ are both 1-methylcyclopropyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2-methylcyclopropyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 1-phenylcyclopropyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both 2-phenylcyclopropyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both cyclobutyl, and R₃ and R₄ are both methyl; R₁ and R₂ are both cyclopentyl, and R₃ and R₄ are both methyl; R₁ is cyclopropyl, R₂ is phenyl, and R₃ and R₄ are both methyl.

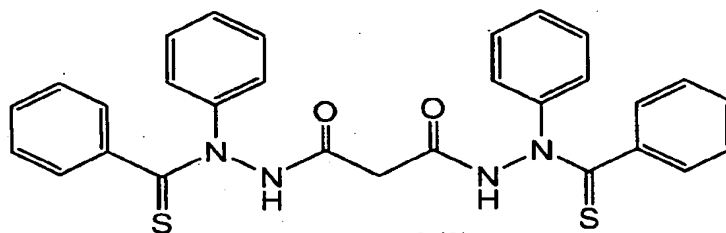
Preferred examples of bis(thio-hydrazide amides) include Compounds (1)-(18) and pharmaceutically acceptable salts and solvates thereof:



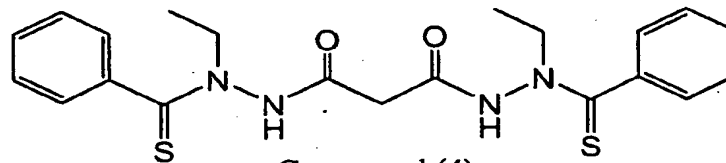
Compound (1)



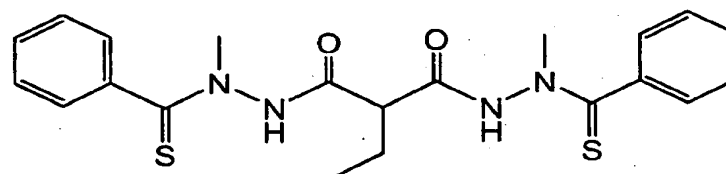
Compound (2)



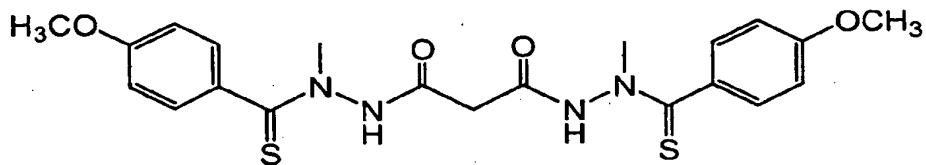
Compound (3)



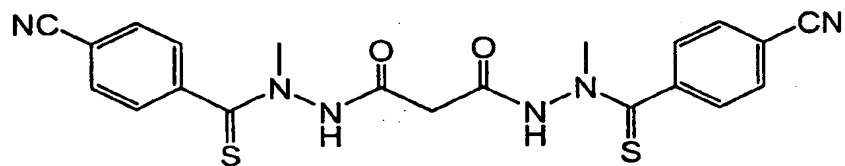
Compound (4)



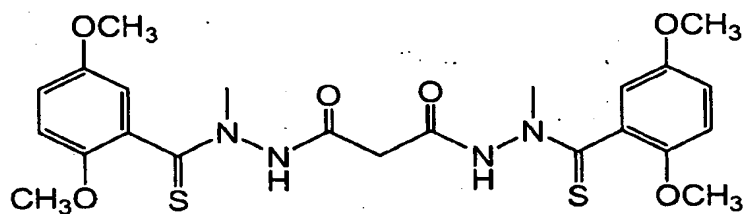
Compound (5)



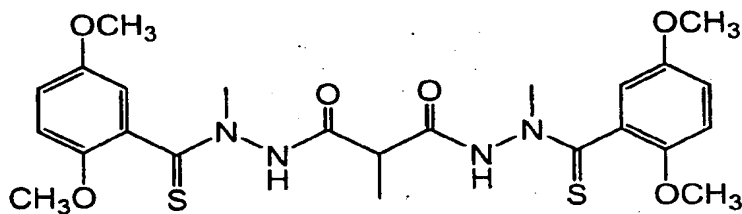
Compound (6)



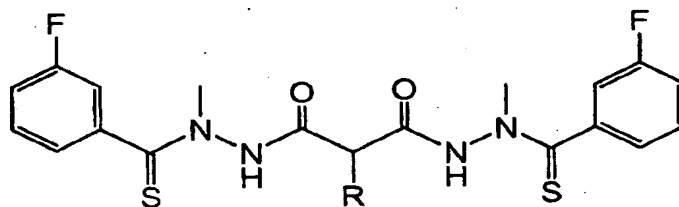
Compound (7)



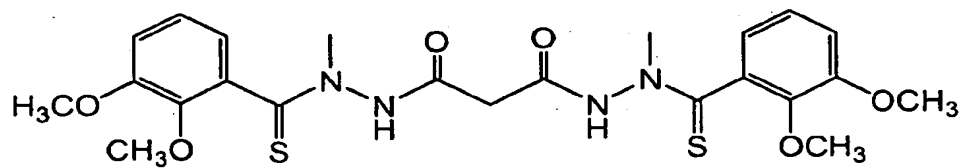
Compound (8)



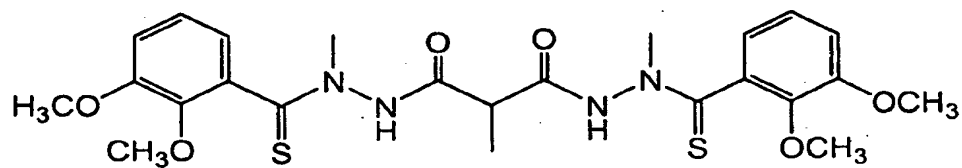
Compound (9)



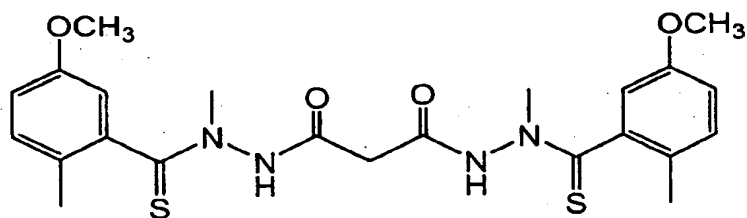
Compound (10)



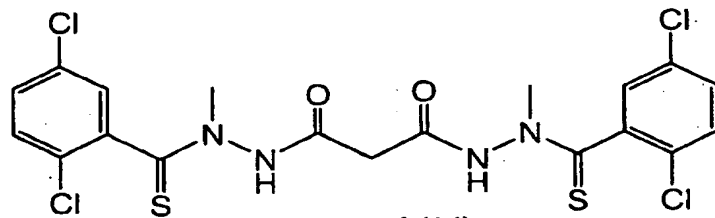
Compound (11)



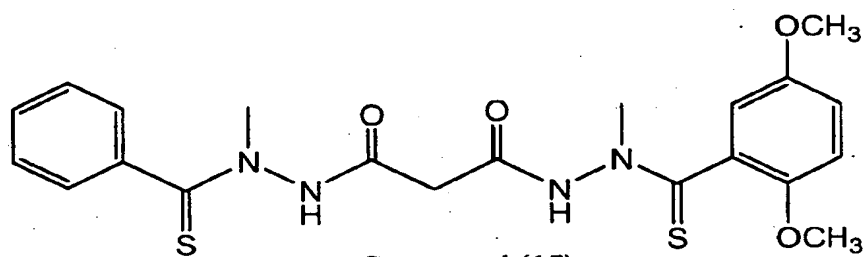
Compound (12)



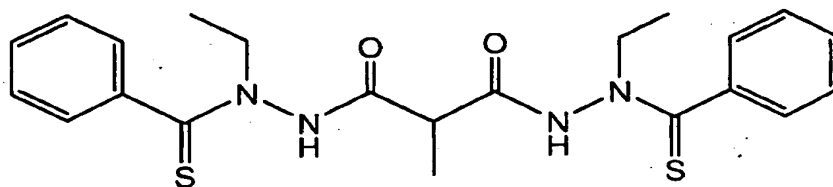
Compound (13)



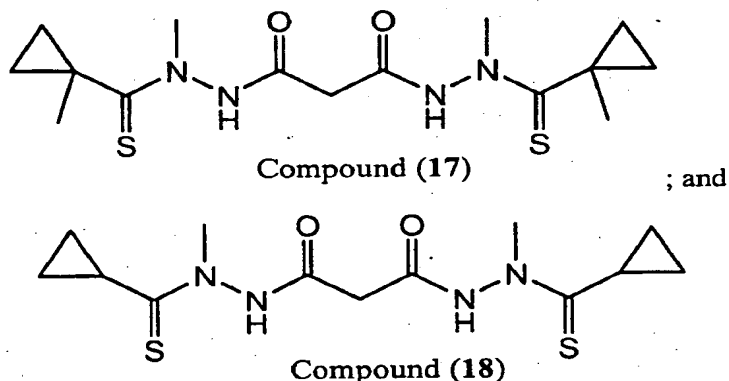
Compound (14)



Compound (15)



Compound (16)



As used herein, the term “bis(thio-hydrazide amide)” and references to the Structural Formulas of this invention also include pharmaceutically acceptable salts and solvates of these compounds and Structural Formulas. Examples of acceptable salts and solvates are described in US Publication No.: 20060135595 and US Patent Application Serial No.: 11/432,307 filed 11-May-2006, titled Synthesis Of Bis(Thio-Hydrazide Amide) Salts, the entire contents of each of which are incorporated herein by reference.

It is to be understood when one tautomeric form of a disclosed compound is depicted structurally, other tautomeric forms are also encompassed.

Certain compounds of the invention may be obtained as different stereoisomers (e.g., diastereomers and enantiomers). The invention includes all isomeric forms and racemic mixtures of the disclosed compounds and methods of treating a subject with both pure isomers and mixtures thereof, including racemic mixtures. Stereoisomers can be separated and isolated using any suitable method, such as chromatography.

An “alkyl group” is saturated straight or branched chain linear or cyclic hydrocarbon group. Typically, a straight chained or branched alkyl group has from 1 to about 20 carbon atoms, preferably from 1 to about 10, and a cyclic alkyl group has from 3 to about 10 carbon atoms, preferably from 3 to about 8. An alkyl group is preferably a straight chained or branched alkyl group, e.g, methyl, ethyl, *n*-propyl, *iso*-propyl, *n*-butyl, *sec*-butyl, *tert*-butyl, pentyl, hexyl, pentyl or octyl, or a cycloalkyl group with 3 to about 8 carbon atoms. A C1-C8 straight chained or branched alkyl group or a C3-C8 cyclic alkyl group is also referred to as a “lower alkyl” group. Suitable substituents for an alkyl group are those which do not substantially interfere with the anti-cancer activity of the disclosed compounds. Suitable substituents are as described below for aliphatic groups. Preferred substituents on alkyl groups include, -OH, -NH₂, -NO₂, -CN, -COOH, halogen, aryl, C1-C8 alkoxy, C1-C8 haloalkoxy and -CO(C1-C8 alkyl). More preferred substituents on alkyl groups include -OH,

halogen, phenyl, benzyl, pyridyl, and C1-C8 alkoxy. More preferred substituents on alkyl groups include -OH, halogen, and C1-C4 alkoxy.

A "straight chained hydrocarbyl group" is an alkylene group, i.e., $-(CH_2)_y-$, with one or more (preferably one) internal methylene groups optionally replaced with a linkage group.
5 y is a positive integer (e.g., between 1 and 10), preferably between 1 and 6 and more preferably 1 or 2. A "linkage group" refers to a functional group which replaces a methylene in a straight chained hydrocarbyl. Examples of suitable linkage groups include a ketone ($-C(O)-$), alkene, alkyne, phenylene, ether ($-O-$), thioether ($-S-$), or amine ($-N(R^a)-$), wherein R^a is defined below. A preferred linkage group is $-C(R_5R_6)-$, wherein R_5 and R_6 are defined
10 above. Suitable substituents for an alkylene group and a hydrocarbyl group are those which do not substantially interfere with the anti-cancer activity of the disclosed compounds. R_5 and R_6 are preferred substituents for an alkylene or hydrocarbyl group represented by Y .

An aliphatic group is a straight chained, branched or cyclic non-aromatic hydrocarbon which is completely saturated or which contains one or more units of unsaturation. Typically,
15 a straight chained or branched aliphatic group has from 1 to about 20 carbon atoms, preferably from 1 to about 10, and a cyclic aliphatic group has from 3 to about 10 carbon atoms, preferably from 3 to about 8. An aliphatic group is preferably a straight chained or branched alkyl group, e.g. methyl, ethyl, *n*-propyl, *iso*-propyl, *n*-butyl, *sec*-butyl, *tert*-butyl, pentyl, hexyl, pentyl or octyl, or a cycloalkyl group with 3 to about 8 carbon atoms. A C1-C8
20 straight chained or branched alkyl group or a C3-C8 cyclic alkyl group is also referred to as a "lower alkyl" group.

The term "aromatic group" may be used interchangeably with "aryl," "aryl ring," "aromatic ring," "aryl group" and "aromatic group." Aromatic groups include carbocyclic aromatic groups such as phenyl, naphthyl, and anthracyl, and heteroaryl groups such as
25 imidazolyl, thienyl, furanyl, pyridyl, pyrimidy, pyranyl, pyrazolyl, pyrrolyl, pyrazinyl, thiazole, oxazolyl, and tetrazole. The term "heteroaryl group" may be used interchangeably with "heteroaryl," "heteroaryl ring," "heteroaromatic ring" and "heteroaromatic group." Heteroaryl groups are aromatic groups that comprise one or more heteroatom, such as sulfur, oxygen and nitrogen, in the ring structure. Preferably, heteroaryl groups comprise from one to
30 four heteroatoms.

Aromatic groups also include fused polycyclic aromatic ring systems in which a carbocyclic aromatic ring or heteroaryl ring is fused to one or more other heteroaryl rings. Examples include benzothienyl, benzofuranyl, indolyl, quinolinyl, benzothiazole, benzooxazole, benzimidazole, quinolinyl, isoquinolinyl and isoindolyl.

Non-aromatic heterocyclic rings are non-aromatic rings which include one or more heteroatoms such as nitrogen, oxygen or sulfur in the ring. The ring can be five, six, seven or eight-membered. Preferably, heterocyclic groups comprise from one to about four heteroatoms. Examples include tetrahydrofuranyl, tetrahydrothiophenyl, morpholino, thiomorpholino, pyrrolidinyl, piperazinyl, piperidinyl, and thiazolidinyl.

Suitable substituents on an aliphatic group (including an alkylene group), non-aromatic heterocyclic group, benzylic or aryl group (carbocyclic and heteroaryl) are those which do not substantially interfere with the anti-cancer activity of the disclosed compounds. A substituent substantially interferes with anti-cancer activity when the anti-cancer activity is reduced by more than about 50% in a compound with the substituent compared with a compound without the substituent. Examples of suitable substituents include -R^a, -OH, -Br, -Cl, -I, -F, -OR^a, -O-COR^a, -COR^a, -CN, -NO₂, -COOH, -SO₃H, -NH₂, -NHR^a, -N(R^aR^b), -COOR^a, -CHO, -CONH₂, -CONHR^a, -CON(R^aR^b), -NHCOR^a, -NR^cCOR^a, -NHCONH₂, -NHCONR^aH, -NHCON(R^aR^b), -NR^cCONH₂, -NR^cCONR^aH, -NR^cCON(R^aR^b), -C(=NH)-NH₂, -C(=NH)-NHR^a, -C(=NH)-N(R^aR^b), -C(=NR^c)-NH₂, -C(=NR^c)-NHR^a, -C(=NR^c)-N(R^aR^b), -NH-C(=NH)-NH₂, -NH-C(=NH)-NHR^a, -NH-C(=NH)-N(R^aR^b), -NH-C(=NR^c)-NH₂, -NH-C(=NR^c)-NHR^a, -NH-C(=NR^c)-N(R^aR^b), -NR^dH-C(=NH)-NH₂, -NR^d-C(=NH)-NHR^a, -NR^d-C(=NH)-N(R^aR^b), -NR^d-C(=NR^c)-NH₂, -NR^d-C(=NR^c)-NHR^a, -NR^d-C(=NR^c)-N(R^aR^b), -NHNH₂, -NHNHR^a, -NHR^aR^b, -SO₂NH₂, -SO₂NHR^a, -SO₂NR^aR^b, -CH=CHR^a, -CH=CR^aR^b, -CR^c=CR^aR^b, -CR^c=CHR^a, -CR^c=CR^aR^b, -CCR^a, -SH, -SR^a, -S(O)R^a, -S(O)₂R^a.

R^a-R^d are each independently an alkyl group, aromatic group, non-aromatic heterocyclic group or -N(R^aR^b), taken together, form a non-aromatic heterocyclic group. The alkyl, aromatic and non-aromatic heterocyclic group represented by R^a-R^d and the non-aromatic heterocyclic group represented by -N(R^aR^b) are each optionally and independently substituted with one or more groups represented by R[#]. Preferably R^a-R^d are unsubstituted.

R[#] is R⁺, -OR⁺, -O(haloalkyl), -SR⁺, -NO₂, -CN, -NCS, -N(R⁺)₂, -NHCO₂R⁺, -NHC(O)R⁺, -NHNHC(O)R⁺, -NHC(O)N(R⁺)₂, -NHNHC(O)N(R⁺)₂, -NHNHCO₂R⁺, -C(O)C(O)R⁺, -C(O)CH₂C(O)R⁺, -CO₂R⁺, -C(O)R⁺, -C(O)N(R⁺)₂, -OC(O)R⁺, -OC(O)N(R⁺)₂, -S(O)₂R⁺, -SO₂N(R⁺)₂, -S(O)R⁺, -NHSO₂N(R⁺)₂, -NHSO₂R⁺, -C(=S)N(R⁺)₂, or -C(=NH)-N(R⁺)₂.

R⁺ is -H, a C1-C4 alkyl group, a monocyclic heteroaryl group, a non-aromatic heterocyclic group or a phenyl group optionally substituted with alkyl, haloalkyl, alkoxy, haloalkoxy, halo, -CN, -NO₂, amine, alkylamine or dialkylamine. Preferably R⁺ is

unsubstituted. Optionally, the group $-N(R^+)_2$ is a non-aromatic heterocyclic group, provided that non-aromatic heterocyclic groups represented by R^+ and $-N(R^+)_2$ that comprise a secondary ring amine are optionally acylated or alkylated.

Preferred substituents for a phenyl group, including phenyl groups represented by R_1 - R_4 , include C1-C4 alkyl, C1-C4 alkoxy, C1-C4 haloalkyl, C1-C4 haloalkoxy, phenyl, benzyl, pyridyl, -OH, -NH₂, -F, -Cl, -Br, -I, -NO₂ or -CN. More preferred for a phenyl group, including phenyl groups represented by R_1 - R_4 , include R_1 and R_2 are optionally substituted with -OH, -CN, halogen, C1-4 alkyl or C1-C4 alkoxy

Preferred substituents for a cycloalkyl group, including cycloalkyl groups represented by R_1 and R_2 , are alkyl groups, such as a methyl or ethyl group.

The bis(thio-hydrazide amide) disclosed herein can be prepared by the methods described in U.S. Publication Nos. 20060135595, 2003/0045518 and 2003/0119914, U.S. Application Serial No.: 11/432,307, filed 11-May-2006, titled Synthesis Of Bis(Thio-Hydrazide Amide) Salts, U.S. Provisional Patent No.: 60/708,977 filed 16-Aug-2005, titled Bis(Thio-Hydrazide Amide) Formulation and also according to methods described in U.S. Publication No. 2004/0225016 A1, entitled TREATMENT FOR CANCERS. The entire teachings of these applications are incorporated herein by reference.

The present invention is illustrated by the following examples, which are not intended to be limiting in any way.

EXAMPLE 1: Purification of Compound 1

Compound 1 used in the following purification procedures was prepared by the following procedure. 274.3 kg of RO/DI water was added to a reactor (10 °C). 5.475 g of NaOH pellets were added until a clear solution was obtained. 28.35 kg of S-(thiobenzoyl)thioglycolic acid was added to the reactor (0-5 °C). 7.965 kg of methylhydrazine was added to the reactor while stirring (0-10 °C). The reactor temperature was increased to 20.0 °C over 150 minutes. The precipitate of thiobenzoyl-N¹-methylhydrazide (19.05 kg) was collected.

18.95 kg of thiobenzoyl-N¹-methylhydrazide was added to a reactor and 221.6 kg of anhydrous ethyl acetate was added with stirring. After the material was dissolved, the reactor was cooled to 4.0 °C. 12.13 kg of TEA was added to the reactor, followed by a solution of malonyl chloride (9.30 kg) in anhydrous ethyl acetate (34.0kg) (-5 to 10 °C). The reactor temperature was increased to 11.4 °C over 95 min. 96.15 kg of RO/DI water was added (2.5 °C +/- 2.5 °C) and stirred for 20 min. NaCl solution (11.430 kg in 19.07 kg RO/DI water) was added in two portions (draining aqueous layer after each addition) and stirred (27 min, 19

min). The organic layer was washed with ACS ethyl acetate. Ethyl acetate was removed by distillation at 100 +/- 50 mm Hg (23-28 °C). The cake was washed with ethyl acetate. The product was dried under vacuum and N-malonyl-bis(N'-methyl-N'-thiobenzoylhydrazide) (15.233 kg) was collected.

5 *Purification procedure (THF-CH₃CN-H₂O):* To a solution of Compound 1 (2g, 95%) in THF (20ml) was added CH₃CN (6ml), cooled to 0-4 °C. To the mixture was added cold water (0-4 °C, 60ml) with stirring. The whole solution was stirred for 3 h followed by filtration. The precipitate was washed with cold THF-H₂O (1:3, v/v), and dried to give Compound 1 (1.8 g, 98%).

10 *Purification procedure (THF-Acetone-H₂O):* To a solution of Compound 1 (2g, 95%) in THF (20ml) was added acetone (6ml), cooled to 0-4 °C. To the mixture was added cold water (0-4 °C, 60ml) with stirring. The whole solution was stirred for 3 hr, and filtered. The precipitate was washed with cold THF-H₂O (1:3), and dried to give Compound 1 in a yield and purity similar to the method described above.

15 99+% pure Compound 1 was obtained by combination of the above two procedures sequentially.

The data from purification procedures with Compound 1 is provided in Tables 1 and 2.

20

Table 1

#	Solvent	Comp # 1	Time	T(°C)	Purity (230nm) %	Impurity %	Purity (254nm) %	Impurity %	Recovery %
1	ETOH (5.5mL)	0.55g	3-4h	RT	95.5	3.7	96.7	2.4	87 (0.48g)
2	MeOH (5.5mL)	0.55g	3-4h	RT	96.7	3.0	97.3	2.1	73 (0.4g)
3	THF-Acetone-Water (265mL)	5g	3-4h	0-4	96.8	2.3	97.5	1.5	>91

4	THF-Acetone-Water (265mL) THF-Water washing	5g	3-4h	0-4	96.9	1.98	97.9	1.38	91 (4.6g)
5	THF-Acetone-Water & THF-CH ₃ CN-Water	1g	3-4h	0-4	97.8	1.3	98.3	0.8	>82
6	THF-Acetone-Water & THF-CH ₃ CN-Water THF-Water Washing	1g	3-4h	0-4	97.8	1.5	98.8	0.7	82
7	THF-CH ₃ CN-Water	5g	3-4h	0-4	97.3	2.0	98.0	1.3	>90
8	THF-CH ₃ CN-Water THF-Water Washing	5g	3-4h	0-4	97.8	1.9	98.1	1.2	90 (4.5g)
9	THF-CH ₃ CN-Water (less volume 86mL)	2g	3-4h	0-4	97.8	1.7	98.3	1.0	>90
10	THF-CH ₃ CN-Water (less volume) THF-Water Washing	2g	3-4h	0-4	98.1	1.6	98.5	0.95	90

11	THF-Acetone-Water (less volume) THF-Water washing	2g	3-4h	0-4	98.0	1.6	98.3	1.0	90 (1.8g)
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Table 2

Exp.	SM mmol	Solvent	Conc. mM	T (°C)	Hours	Recovery (%)	Purity (%) 254; 230nm	Imp.(%) 254;230nm
1	12.5	THF-acetone-H ₂ O	48	0-4	4	91	97.5; 96.8	1.5;2.3
2	12.5	THF-acetone- H ₂ O With THF- H ₂ O washing	48	0-4	4	91	97.9; 96.9	1.38;1.98
3	2.5	Expt.4 plus THF- CH ₃ CN- H ₂ O	48	0-4	4	82	98.3; 97.8	0.8;1.3
4	2.5	Expt.4 plus THF- CH ₃ CN- H ₂ O With THF- H ₂ O washing	48	0-4	4	82	98.8; 97.8	0.7;1.5
5	12.5	THF-CH ₃ CN- H ₂ O	48	0-4	4	90	98.0; 97.3	1.3;2.0
6	12.5	THF-CH ₃ CN- H ₂ O With THF- H ₂ O washing	48	0-4	4	90	98.1; 97.8	1.2
7	5	THF-CH ₃ CN- H ₂ O *	48	0-4	4	90	98.3; 97.8	1.0;1.7
8	5	THF-CH ₃ CN- H ₂ O * With THF- H ₂ O washing	48	0-4	4	90	98.5; 98.1	0.95;1.6
9	5	THF-acetone- H ₂ O * With THF- H ₂ O washing	48	0-4	4	90	98.3; 98.0	1.0;1.6
10	2.5	Expt. 8 plus Expt. 9	48	0-4	4	90	99.2; 99.5	0.43; 0.35
11	1.8	Expt. 8 plus Expt. 9*	48	0-4	4	85	99.3; 99.4	0.35; 0.33

5

* with less water

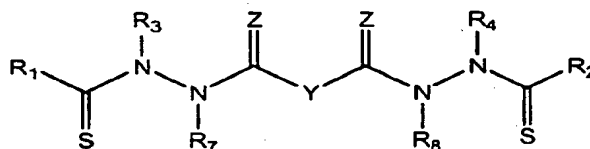
While this invention has been particularly shown and described with references to preferred embodiments thereof, it will be understood by those skilled in the art that various

changes in form and details may be made therein without departing from the scope of the invention encompassed by the appended claims.

CLAIMS

What is claimed is:

1. A method of purifying a compound represented by the following Structural Formula:



wherein:

Y is a covalent bond or an optionally substituted straight chained hydrocarbyl group, or, Y, taken together with both $>\text{C}=\text{Z}$ groups to which it is bonded, is an optionally substituted aromatic group;

R_1 - R_4 are independently -H, an optionally substituted aliphatic group, an optionally substituted aryl group, or R_1 and R_3 taken together with the carbon and nitrogen atoms to which they are bonded, and/or R_2 and R_4 taken together with the carbon and nitrogen atoms to which they are bonded, form a non-aromatic heterocyclic ring optionally fused to an aromatic ring;

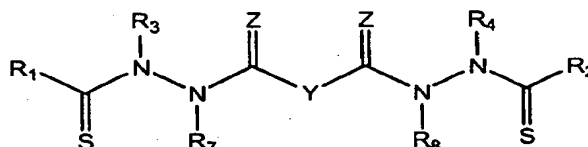
R_7 - R_8 are independently -H, an optionally substituted aliphatic group, or an optionally substituted aryl group; and

Z is O or S;

comprising dissolving the compound in a solvent selected from the group consisting of THF-acetone, THF- CH_3CN , THF, acetone, CH_3CN , THF-EtOH, or acetone-EtOH, and precipitating the compound with water.

2. The method of Claim 1, further comprising washing the precipitate with THF-water.
3. The method of Claim 2, wherein the THF-water is in a ratio of 1:3 (v/v).
4. The method of Claim 1, wherein the compound, solvent, and water are stirred for 3 to 4 hours.
5. The method of Claim 4, wherein the temperature is 0-4 °C.

6. The method of Claim 1 or 2, further comprising dissolving the precipitate in a second solvent selected from the group consisting of THF-acetone, THF-CH₃CN, THF, acetone, CH₃CN, THF-EtOH, or acetone-EtOH, and precipitating the compound with water.
7. The method of Claim 6, further comprising washing the precipitate with THF-water.
8. The method of Claim 7, wherein the THF-water is in a ratio of 1:3 (v/v).
9. The method of Claim 6, wherein the compound, second solvent, and water are stirred for 3 to 4 hours.
10. The method of Claim 9, wherein the temperature is 0-4 °C.
11. A method of purifying a compound represented by the following Structural Formula:



wherein:

Y is a covalent bond or an optionally substituted straight chained hydrocarbyl group, or, Y, taken together with both >C=Z groups to which it is bonded, is an optionally substituted aromatic group;

R₁-R₄ are independently -H, an optionally substituted aliphatic group, an optionally substituted aryl group, or R₁ and R₃ taken together with the carbon and nitrogen atoms to which they are bonded, and/or R₂ and R₄ taken together with the carbon and nitrogen atoms to which they are bonded, form a non-aromatic heterocyclic ring optionally fused to an aromatic ring;

R₇-R₈ are independently -H, an optionally substituted aliphatic group, or an optionally substituted aryl group; and

Z is O or S;

comprising dissolving the compound in a solvent selected from the group consisting of THF-acetone or THF-CH₃CN, and precipitating the compound with water.

12. The method of Claim 11, further comprising washing the precipitate with THF-water.
13. The method of Claim 12, wherein the THF-water is in a ratio of 1:3 (v/v).
- 5 14. The method of Claim 11, wherein the compound, solvent, and water are stirred for 3 to 4 hours.
15. The method of Claim 14, wherein the temperature is 0-4 °C.
- 10 16. The method of Claim 11 or 12, further comprising dissolving the precipitate in a second solvent selected from the group consisting of THF-acetone or THF-CH₃CN, and precipitating the compound with water.
- 15 17. The method of Claim 16, further comprising washing the precipitate with THF-water.
18. The method of Claim 17, wherein the THF-water is in a ratio of 1:3 (v/v).
19. The method of Claim 16, wherein the compound, second solvent, and water are
- 20 20. stirred for 3 to 4 hours.
20. The method of Claim 19, wherein the temperature is 0-4 °C.
21. The method of Claim 11, wherein the solvent is THF-acetone.
- 25 22. The method of Claim 11, wherein the solvent is THF-CH₃CN.
23. The method of Claim 16, wherein the second solvent is THF-acetone.
- 30 24. The method of Claim 16, wherein the second solvent is THF-CH₃CN.
25. The method of Claim 16, wherein the solvent is THF-acetone and the second solvent is THF-CH₃CN.

26. The method of Claim 16, wherein the solvent is THF-CH₃CN and the second solvent is THF-acetone.
27. The method of any one of Claims 11-26, wherein Z is O, R₁ and R₂ are the same and R₃ and R₄ are the same.
28. The method of Claim 27, wherein:
 Y is a covalent bond, -C(R₅R₆)-, -(CH₂CH₂)-, *trans*-(CH=CH)-, *cis*-(CH=CH)- or -(C≡C)-; and
 R₅ and R₆ are each independently -H, an aliphatic or substituted aliphatic group, or R₅ is -H and R₆ is an optionally substituted aryl group, or, R₅ and R₆, taken together, are an optionally substituted C2-C6 alkylene group.
29. The method of Claim 28, wherein:
 Y is -C(R₅R₆)-;
 R₁ and R₂ are each an optionally substituted aryl group; and
 R₃ and R₄ are each an optionally substituted aliphatic group.
30. The method of Claim 29, wherein R₅ is -H and R₆ is -H, an aliphatic or substituted aliphatic group.
31. The method of Claim 30, wherein R₃ and R₄ are each an alkyl group optionally substituted with -OH, halogen, phenyl, benzyl, pyridyl, or C1-C8 alkoxy and R₆ is -H or methyl.
32. The method of Claim 31, wherein R₁ and R₂ are each an optionally substituted phenyl group.
33. The method of Claim 32, wherein the phenyl group represented by R₁ and the phenyl group represented by R₂ are optionally substituted with one or more groups selected from: -R^a, -OH, -Br, -Cl, -I, -F, -OR^a, -O-COR^a, -COR^a, -CN, -NCS, -NO₂, -COOH, -SO₃H, -NH₂, -NHR^a, -N(R^aR^b), -COOR^a, -CHO, -CONH₂, -CONHR^a, -CON(R^aR^b), -NHCOR^a, -NR^cCOR^a, -NHCONH₂, -NHCONR^aH, -NHCON(R^aR^b), -NR^cCONH₂, -NR^cCONR^aH, -NR^cCON(R^aR^b), -C(=NH)-NH₂, -C(=NH)-NHR^a, -C(=NH)-N(R^aR^b),

-C(=NR^c)-NH₂, -C(=NR^c)-NHR^a, -C(=NR^c)-N(R^aR^b), -NH-C(=NH)-NH₂,
 -NH-C(=NH)-NHR^a, -NH-C(=NH)-N(R^aR^b), -NH-C(=NR^c)-NH₂,
 -NH-C(=NR^c)-NHR^a, -NH-C(=NR^c)-N(R^aR^b), -NR^d-C(=NH)-NH₂,
 -NR^d-C(=NH)-NHR^a, -NR^d-C(=NH)-N(R^aR^b), -NR^d-C(=NR^c)-NH₂,
 -NR^d-C(=NR^c)-NHR^a, -NR^d-C(=NR^c)-N(R^aR^b), -NHNH₂, -NHNHR^a, -NHN(R^aR^b),
 -SO₂NH₂, -SO₂NHR^a, -SO₂NR^aR^b, -CH=CHR^a, -CH=CR^aR^b,
 -CR^c=CR^aR^b, -CR^c=CHR^a, -CR^c=CR^aR^b, -CCR^a, -SH, -SR^a, -S(O)R^a, -S(O)₂R^a,

wherein R^a-R^d are each independently an alkyl group, aromatic group, non-aromatic heterocyclic group; or, -N(R^aR^b), taken together, form an optionally substituted

non-aromatic heterocyclic group, wherein the alkyl, aromatic and non-aromatic heterocyclic group represented by R^a-R^d and the non-aromatic heterocyclic group represented by -N(R^aR^b) are each optionally and independently substituted with one or more groups represented by R[#], wherein R[#] is R⁺, -OR⁺, -O(haloalkyl), -SR⁺, -NO₂, -CN, -NCS, -N(R⁺)₂, -NHCO₂R⁺, -NHC(O)R⁺, -NHNHC(O)R⁺, -NHC(O)N(R⁺)₂, -NHNHC(O)N(R⁺)₂, -NHNHCO₂R⁺, -C(O)C(O)R⁺, -C(O)CH₂C(O)R⁺, -CO₂R⁺, -C(O)R⁺, C(O)N(R⁺)₂, -OC(O)R⁺, -OC(O)N(R⁺)₂, -S(O)₂R⁺, -SO₂N(R⁺)₂, -S(O)R⁺, -NHSO₂N(R⁺)₂, -NHSO₂R⁺, -C(=S)N(R⁺)₂, or -C(=NH)-N(R⁺)₂; wherein R⁺ is -H, a C1-C4 alkyl group, a monocyclic heteroaryl group, a non-aromatic heterocyclic group or a phenyl group optionally substituted with alkyl, haloalkyl, alkoxy, haloalkoxy, halo, -CN, -NO₂, amine, alkylamine or dialkylamine; or -N(R⁺)₂ is a non-aromatic heterocyclic group, provided that non-aromatic heterocyclic groups represented by R⁺ and -N(R⁺)₂ that comprise a secondary ring amine are optionally acylated or alkylated.

- 25 34. The method of Claim 33, wherein the phenyl groups represented by R₁ and R₂ are optionally substituted with C1-C4 alkyl, C1-C4 alkoxy, C1-C4 haloalkyl, C1-C4 haloalkoxy, phenyl, benzyl, pyridyl, -OH, -NH₂, -F, -Cl, -Br, -I, -NO₂ or -CN.
- 30 35. The method of Claim 34, wherein the phenyl groups represented by R₁ and R₂ are optionally substituted with -OH, -CN, halogen, C1-4 alkyl or C1-C4 alkoxy and R₃ and R₄ are each methyl or ethyl optionally substituted with -OH, halogen or C1-C4 alkoxy.
36. The method of Claim 28, wherein:

Y is $-\text{CR}_5\text{R}_6-$;

R_1 and R_2 are both an optionally substituted aliphatic group;

R_5 is $-\text{H}$; and

R_6 is $-\text{H}$ or an optionally substituted aliphatic group.

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37. The method of Claim 36, wherein R_1 and R_2 are both a C3-C8 cycloalkyl group optionally substituted with at least one alkyl group.

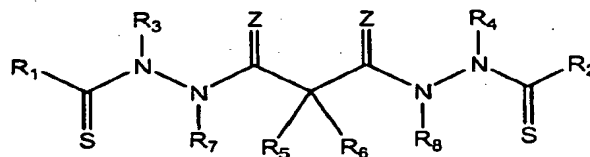
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38. The method of Claim 37, wherein R_3 and R_4 are both an alkyl group optionally substituted with $-\text{OH}$, halogen, phenyl, benzyl, pyridyl, or C1-C8 alkoxy; and R_6 is $-\text{H}$ or methyl.

39. The method of Claim 38, wherein R_1 and R_2 are both cyclopropyl or 1-methylcyclopropyl.

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40. The method of any one of Claims 11-26, wherein the compound is represented by the following Structural Formula:



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wherein:

R_7 - R_8 are both $-\text{H}$, and:

R_1 and R_2 are both phenyl, R_3 and R_4 are both methyl, and R_5 and R_6 are both $-\text{H}$;

25

R_1 and R_2 are both phenyl, R_3 and R_4 are both ethyl, and R_5 and R_6 are both $-\text{H}$;

R_1 and R_2 are both 4-cyanophenyl, R_3 and R_4 are both methyl, R_5 is methyl, and R_6 is $-\text{H}$;

R_1 and R_2 are both 4-methoxyphenyl, R_3 and R_4 are both methyl, and R_5 and R_6 are both $-\text{H}$;

30

R_1 and R_2 are both phenyl, R_3 and R_4 are both methyl, R_5 is methyl, and R_6 is $-\text{H}$;

R₁ and R₂ are both phenyl, R₃ and R₄ are both ethyl, R₅ is methyl, and R₆ is -H;

R₁ and R₂ are both 4-cyanophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

5 R₁ and R₂ are both 2,5-dimethoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 2,5-dimethoxyphenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H;

10 R₁ and R₂ are both 3-cyanophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 3-fluorophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 4-chlorophenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H;

15 R₁ and R₂ are both 2-dimethoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 3-methoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

20 R₁ and R₂ are both 2,3-dimethoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 2,3-dimethoxyphenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H;

R₁ and R₂ are both 2,5-difluorophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

25 R₁ and R₂ are both 2,5-difluorophenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H;

R₁ and R₂ are both 2,5-dichlorophenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

30 R₁ and R₂ are both 2,5-dimethylphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 2,5-dimethoxyphenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both phenyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

- 32 -

R₁ and R₂ are both 2,5-dimethoxyphenyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H;

R₁ and R₂ are both cyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

5 R₁ and R₂ are both cyclopropyl, R₃ and R₄ are both ethyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both cyclopropyl, R₃ and R₄ are both methyl, R₅ is methyl, and R₆ is -H;

10 R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, R₅ is methyl and R₆ is -H;

R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, R₅ is ethyl, and R₆ is -H;

15 R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, R₅ is *n*-propyl, and R₆ is -H;

R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both methyl;

20 R₁ and R₂ are both 1-methylcyclopropyl, R₃ and R₄ are both ethyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 1-methylcyclopropyl, R₃ is methyl, R₄ is ethyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 2-methylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

25 R₁ and R₂ are both 2-phenylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both 1-phenylcyclopropyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

30 R₁ and R₂ are both cyclobutyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both cyclopentyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both cyclohexyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both cyclohexyl, R₃ and R₄ are both phenyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both methyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

5 R₁ and R₂ are both methyl, R₃ and R₄ are both *t*-butyl, and R₅ and R₆ are both -H;

R₁ and R₂ are both methyl, R₃ and R₄ are both phenyl, and R₅ and R₆ are both -H;

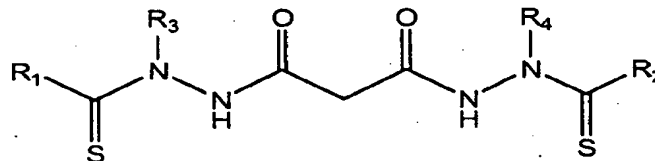
10 R₁ and R₂ are both *t*-butyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;

R₁ and R₂ are ethyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H;
or

R₁ and R₂ are both *n*-propyl, R₃ and R₄ are both methyl, and R₅ and R₆ are both -H.

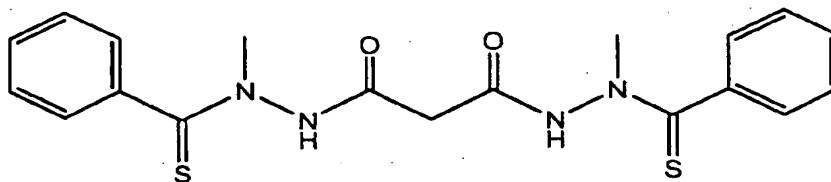
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41. The method of any one of Claims 11-26, wherein the compound is represented by the following Structural Formula:

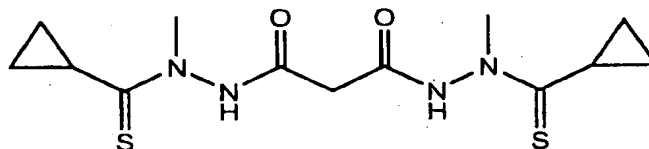
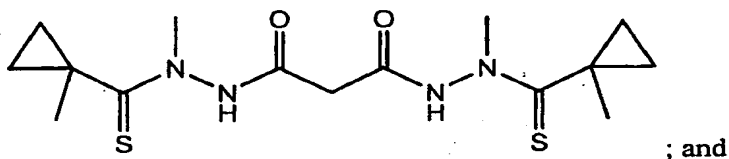


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42. The method of any one of Claims 11-26, wherein the compound is represented by one of the following Structural Formulas:

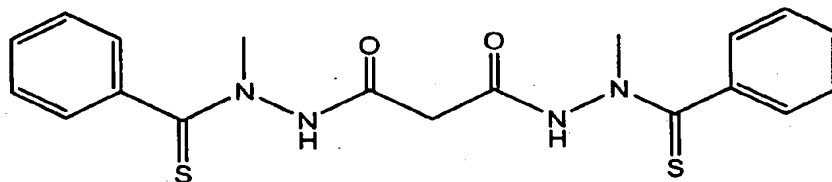


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43. A method of purifying a compound represented by the following Structural Formula:



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comprising dissolving the compound in a solvent selected from the group consisting of THF-acetone or THF-CH₃CN, and precipitating the compound with water.

44. The method of Claim 43, further comprising washing the precipitate with THF-water.

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45. The method of Claim 44, wherein the THF-water is in a ratio of 1:3 (v/v).

46. The method of Claim 43, wherein the compound, solvent, and water are stirred for 3 to 4 hours.

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47. The method of Claim 46, wherein the temperature is 0-4 °C.

48. The method of Claim 43 or 44, further comprising dissolving the precipitate in a second solvent selected from the group consisting of THF-acetone or THF-CH₃CN, and precipitating the compound with water.

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49. The method of Claim 48, further comprising washing the precipitate with THF-water.
50. The method of Claim 49, wherein the THF-water is in a ratio of 1:3 (v/v).
51. The method of Claim 48, wherein the compound, second solvent, and water are stirred for 3 to 4 hours.
52. The method of Claim 51, wherein the temperature is 0-4 °C.
53. The method of Claim 43, wherein the solvent is THF-acetone.
54. The method of Claim 43, wherein the solvent is THF-CH₃CN.
55. The method of Claim 48, wherein the second solvent is THF-acetone.
56. The method of Claim 48, wherein the second solvent is THF-CH₃CN.
57. The method of Claim 48, wherein the solvent is THF-acetone and the second solvent is THF-CH₃CN.
58. The method of Claim 48, wherein the solvent is THF-CH₃CN and the second solvent is THF-acetone.